



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PB67-43001-09

Job Sheet 173135



Part No: PB67-43001-09

Job Qty: 2 ea

Part Name: Aft Blade Fold Assembly Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB 10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/13/18	0.00	0.00	Start Up Large Fab-7		CPL
100	Large Fab	2 pcs		4/14/18	0.00	15.38	Large Fab 2		CPL
110	QC	2 pcs		4/14/18	0.00	0.00	QC9		EL
120	QC	2 pcs		4/14/18	0.00	0.00	QC5		EL
130	Powdercoat	2 pcs		4/16/18	0.00	0.69	Powdercoat5		BR 18-4-18
140	QC	2 pcs		4/16/18	0.00	0.00	QC3		CPL
150	Packaging	2 pcs		4/16/18	0.00	0.00	Packaging3-2		DAT
160	QC21-SA	2 Ea		4/16/18	0.00	0.00	QC21		21 APR 20 2018

Part Op 100 - 1- Assemble parts on jig DT8814 and weld as per dwg PB67-43001 ** Ensure no burn thru after welding in tube
Descriptions: -235 and -229 only where bushing -265 ***

130 - ***MASK ALL OPENING AND INDICATED AREAS PRIOR TO POWDERCOATING, SEE NOTE 9 SHEET 2-3****
FINISH TIME:

M 1380H. START: 2:30 O.N.T. 320° FINISH: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3440-13	Bracket (Supersedes B67-43001-273)	2 Ea (1 ea)	90-Start up Operation	F161141
D3440-9	Tube Detent Clip Base (Supersedes B67-43001-241)	2 Ea (1 ea)	90-Start up Operation	F161142
PB67-43001-201	Square Tube	4 Ea (2 ea)	90-Start up Operation	B160816
PB67-43001-203W	Square Tube Weldment	2 Ea (1 ea)	90-Start up Operation	B160942
PB67-43001-209	Square Tube	2 Ea (1 ea)	90-Start up Operation	B160824
PB67-43001-211	Square Tube	12 Ea (6 ea)	90-Start up Operation	5053269
PB67-43001-213	Flanged Hook	4 Ea (2 ea)	90-Start up Operation	F160931
PB67-43001-229W	Outer Tube Weldment	2 Ea (1 ea)	90-Start up Operation	F160949
PB67-43001-235	Outer Tube	2 Ea (1 ea)	90-Start up Operation	160930
PB67-43001-239W	Square Tube Weldment	2 Ea (1 ea)	90-Start up Operation	505241
PB67-43001-243	Tube Handle Extension	2 Ea (1 ea)	90-Start up Operation	160947
PB67-43001-277	Contoured Male Eye	2 Ea (1 ea)	90-Start up Operation	F148792-2
PB67-43001-311	Restraint	4 Ea (2 ea)	90-Start up Operation	F160933

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3440-13	2	5	0
	D3440-9	2	5	0
	PB67-43001-201	4	15	0
	PB67-43001-203W	2	9	0
	PB67-43001-209	2	10	0
	PB67-43001-211	12	6	0
	PB67-43001-213	4	11	0
	PB67-43001-229W	2	5	0
	PB67-43001-235	2	5	0
	PB67-43001-239W	2	0	0
	PB67-43001-243	2	6	0
	PB67-43001-277	2	5	0
	PB67-43001-311	4	11	0
Part Specifications				
Specifications could not be found.				

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Container No: S060298



Part: PB67 - 43001 - 09

Job No: 173135

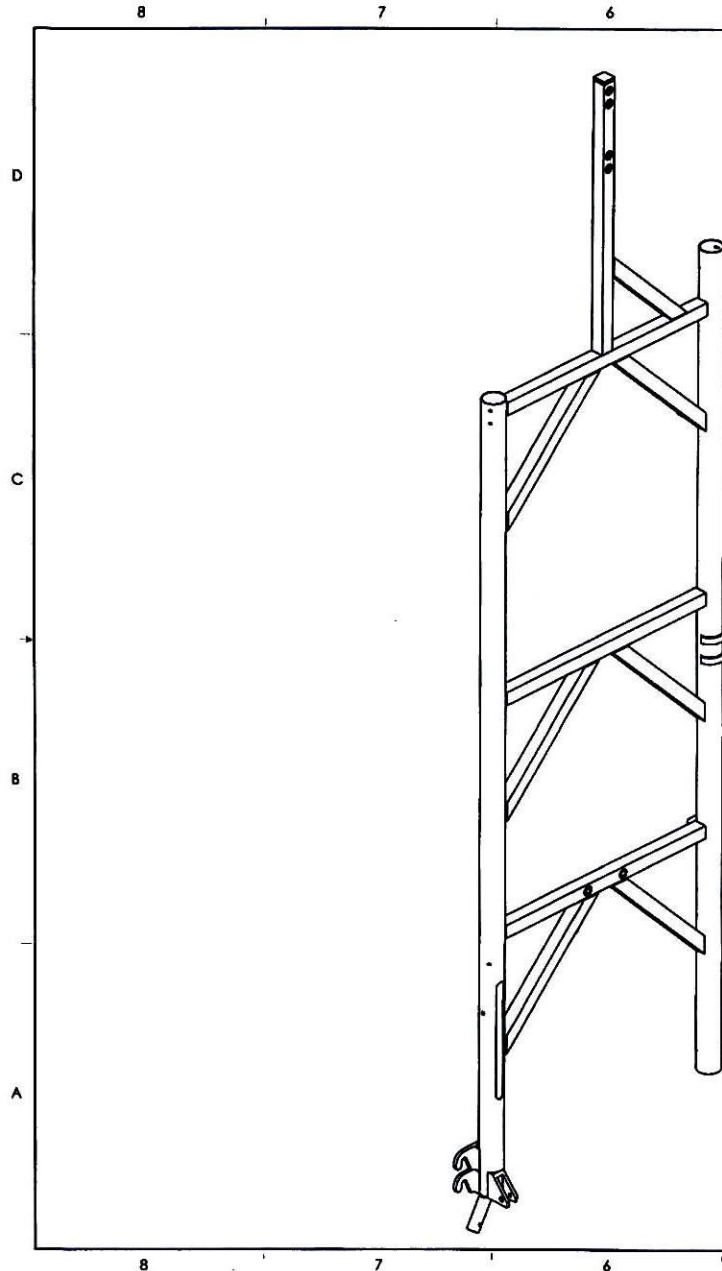
Serial No/Batch: S060298

Revision:

Inspector:

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Date: 04/12/18

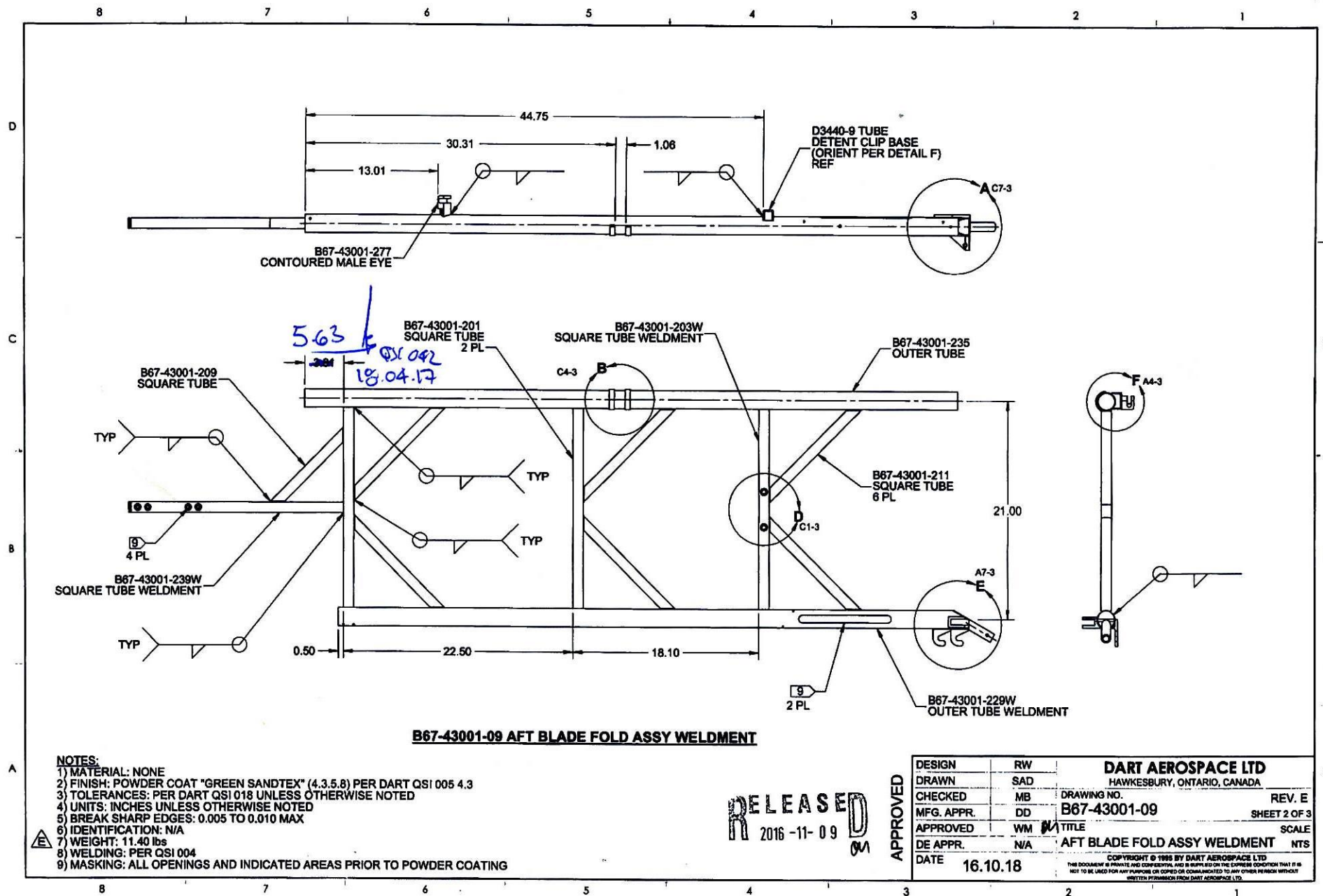


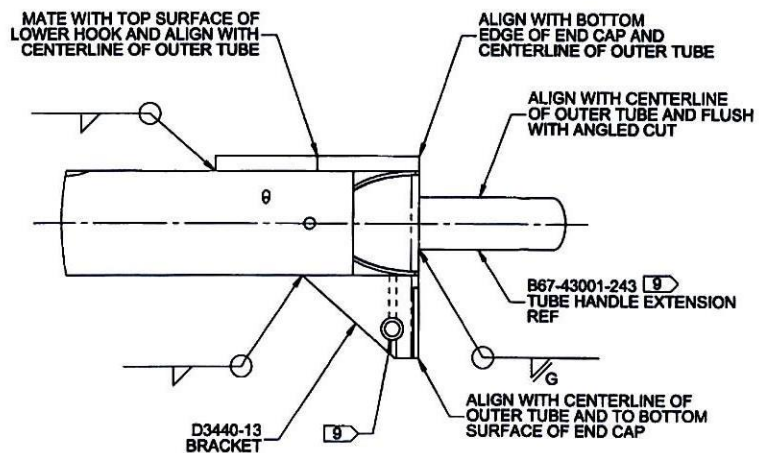
ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
1	2	B67-43001-201	SQUARE TUBE
2	1	B67-43001-203W	SQUARE TUBE WELDMENT
3	1	B67-43001-209	SQUARE TUBE
4	6	B67-43001-211	SQUARE TUBE
5	2	B67-43001-213	FLANGED HOOK
6	1	B67-43001-229W	OUTER TUBE WELDMENT
7	1	B67-43001-235	OUTER TUBE
8	1	B67-43001-239W	SQUARE TUBE WELDMENT
9	1	B67-43001-243	TUBE HANDLE EXTENSION
10	1	B67-43001-277	CONTOURED MALE EYE
11	2	B67-43001-311	RESTRAINT
12	1	D3440-9	TUBE DETENT CLIP BASE
13	1	D3440-13	FLANGE HOOK

E	REMOVE MASKING INSIDE HOOK AREA ON B67-43001-213 (ZNA7-3) VERIFIED MATERIAL SPECIFICATIONS: WEIGHT AFFECTED (ZNA8-2) REASON: PAR15-457	SAD	16.10.18
D	REVISE BOM AND ANNOTATIONS TO INCORPORATE -203W, -229W, -239W WELDMENTS. DELETE DETAIL C (SH 2, 3); REASON: TO FACILITATE MANUFACTURING	DB	14.07.24
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING #B67-43001 REASON: SEE PAR09-011	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. E
CHECKED	MB	B67-43001-09	SHEET 1 OF 3
MFG. APPR.	DD	TITLE	SCALE
APPROVED	WM	AFT BLADE FOLD ASSY WELDMENT	NTS
DE APPR.	N/A	DATE	16.10.18
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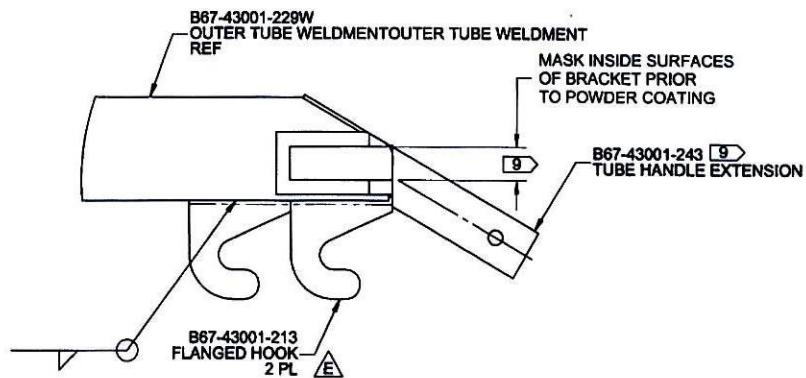
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2016-11-09
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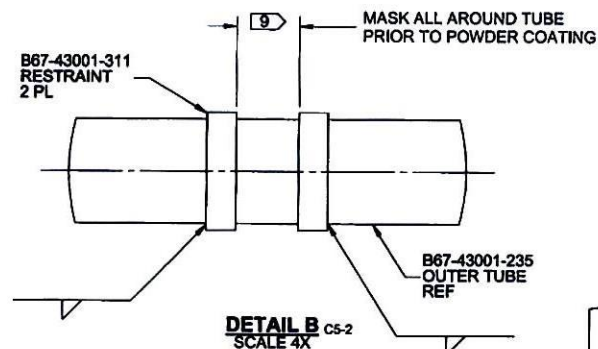




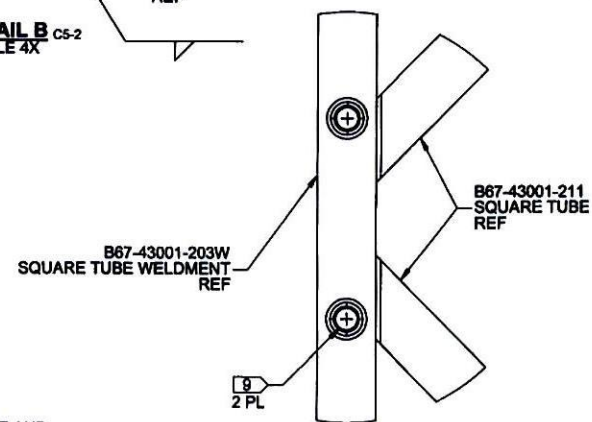
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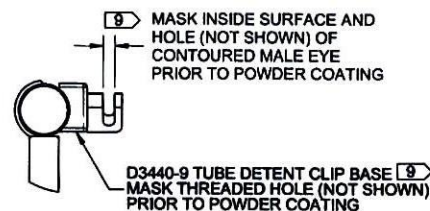
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DETAIL B
CS-2
SCALE 4X



DETAIL D
B4-2
SCALE 4X



DETAIL F
C2-2
SCALE 4X

RELEASED
2016-11-09

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DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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